

Work Order ID 130724

130724

Page 1

Tuesday, March 24, 2015 9:59:36 AM

Item ID: D3023-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Panel

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MJS*

Date: *1503-24*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3023

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: *B*

Prog Rev: *B*

***graind direction along 28.100" ***

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1 *Ø* *Jm15-3-24*

1 *Ø* *Jm15-3-24*

2024-032

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							DAS 38 9-89 MAR 27 2015
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00			DAS 30 9-89	1			15/03/20
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 38 9-89 MAR 30 2015

DQA: _____ Date: _____



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Equip/Tooling									
Handling/Pre									
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Run Start ***NR1***

QC:

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SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

1 / 15-3-31 Doc

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS

38

9-89

MAR 31 2015

180

Identify as per dwg & Stock Location: WA001

0.00

180

Packaging

Memo

0.00

Packaging

DAS

27

9-89

MAR 31 2015

DQA: _____ Date: _____



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Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Work Order ID 130724***130724***

Page 4

Tuesday, March 24, 2015 9:59:36 AM

Item ID: D3023-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Panel

Start Date: 3/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MJS 1504-01

MS331

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Training									
Transport									
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Picklist Print

Tuesday, March 24, 2015 9:59:43 AM

Page 1

Work Order ID: 130724

130724

Parent Item: D3023-1

D3023-1

Parent Item Name: Back Panel

Start Date: 3/24/2015

Required Date: 3/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

100

sf

68.9060

2.8777

4

M2024T3S 032

**

Jm15-3-24

2024-T3 .032 sheet

Location

Loc Qty

Loc Code

MAT022

68.906

M130497

68.906

130497

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Equip/Tooling									
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DART AEROSPACE LTD		Work Order: 130724
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: AB	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

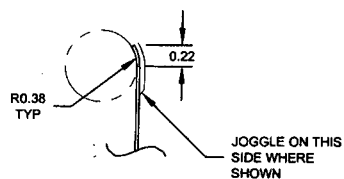
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.130"	-		✓	Jkmo1
Ø0.191	+0.005/-0.001	0.192"	-		✓	
1.660	+/-0.010	1.660"	-		✓	
0.375	+/-0.010	0.375"	-		✓	
1.340	+/-0.010	1.340"	-		✓	
2.375	+/-0.010	2.375"	-		✓	
0.375	+/-0.010	0.375"	-		✓	
25.28	+/-0.030	25.28"	-		✓	Jkmo3
27.03	+/-0.030	27.03"	-		✓	
28.10	+/-0.030	28.10"	-		✓	
1.30	+/-0.030	1.30"	-		✓	
2.375	+/-0.010	2.375"	-		✓	
8.711	+/-0.010	8.711"	-		✓	
5.597	+/-0.010	5.597"	-		✓	
8.57	+/-0.030	8.57"	-		✓	
1.970	+/-0.010	1.970"	-		✓	
7.42	+/-0.030	7.42"	-		✓	
10.92	+/-0.030	10.92"	-		✓	
14.75	+/-0.030	14.75"	-		✓	

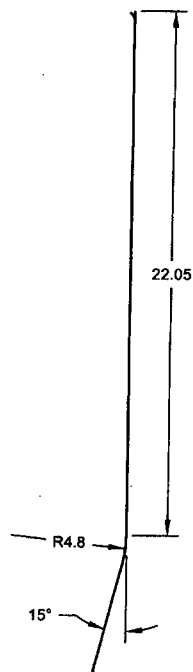
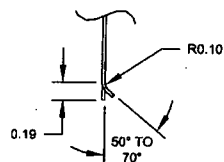
Measured by: Jm	Audited by: 3E	Prototype Approval:	N/A
Date: 15-3-24	Date: MAR 27 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	

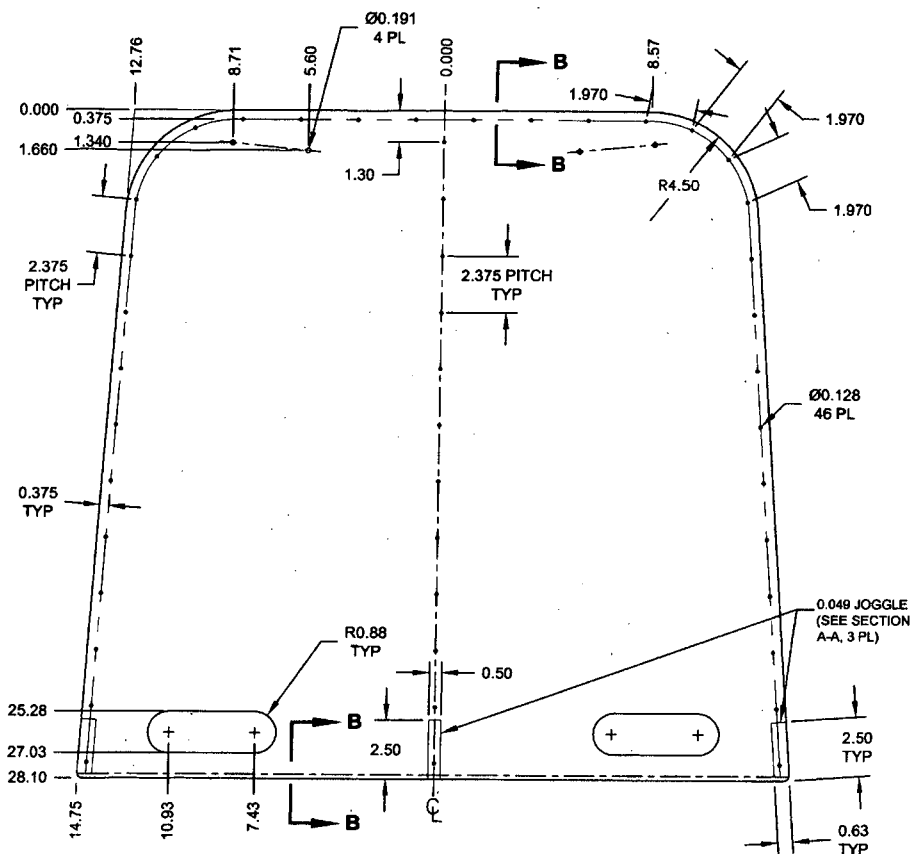
SCALE 4X
TYPICAL EXCEPT WHERE SHOWN



SECTION B-B
SCALE 4X
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

RELEASED

2015 FEB 04

ECN 15-522 *CP*

B	UPDATED FORMAT. POWDER COAT REMOVED TO BE APPLIED AT NEXT ASSEMBLY.		AJS	14.11.13
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3023 TITLE BACK PANEL	REV. E	
DRAWN	AJS		SHEET 1 OF 1	
CHECKED	<i>[Signature]</i>		TITLE	
MFG. APPR.	<i>[Signature]</i>		SCALE	
APPROVED	<i>[Signature]</i>		NT	
DE APPR.	<i>[Signature]</i>	DATE		
DATE		14.11.13 COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY OTHER MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.		